Work Order ID 100249 - 1 *100249* April-22-13 12:51:53 PM Page 1 D4021-5 Item ID: Accept *N900040100* Setup Start Revision ID: Item Name: Blanking Plate Start Date: 4/22/13 Start Qty: 20.00 Cust Item ID: Required Date: 5/03/13 Reg'd Qty: 20.00 Customer: Reference: Run Approvals: Process Plan: Start MUS Date: 13 0424 Tooling: Date: QC: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Work Center ID Accept Reject Description Reject Insp. Run Hours Code Qty Number Stamp Qty Draw Nbr Revision Nbr D4021 100 0.00 *100* Waterjet Memo 0.00 FLOW CNC Waterjet Cut as per dwg D4021 Prog Rev: REV B Dwg Rev: REV B Deburr as required 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110*

0.00

QC

Quality Control

Memo

DQA:		Date:										DADT
					WORK ORDER NON	-C	ONFORMA	ANCE / I	UPDATE			AEROSPACE
QA Closed:		Date:							V	Vork Order u	odate only	TARRESTORIO DE CONCESSORIO
Work Order					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
				-	Rework	1	Skid	-tube	Crosstube		Water Jet	Engineering
Part No).				Scrap			nining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thermofor	ming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	o			_	Suspected Unapproved]	Larg	e Fab	Composite		Supplier	
Root				Desc	ription of work order update		Initial	А	ction	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling	_			9								
Handling/Pre	_											
Material	4	-								1		
Operator	_											
Offset/Setup	_											
Process												
Supplier												
Training	-											
Transport										1		
Unapproved						_						
1 1		- 17				FA	ULT CATEGO	RY.				
Landing	U.S.				General		1- 1: /5	2022	_	7		7.
	Bending Centre No			-	Bend BOM/Bouts	-	Folio/Progra	ım	-	Outside Dim		Pressure/Forced
-	Cracks	ot Concer	itric		BOM/Route Broken/Damage/Defect	\vdash	Grain		-	Over/Under		Set-up
-	Crimp/Kir	ok /Pinnla	/\\/\>		Burrs	H	Hardware	complete/	Unavalified	Part Incorre		Temperature/Cure
200	Cuffs	ik) kibbie	/ vvave	-	1	H	Inspection In	es accompany to the s		Part Lost/Mi		Weld
100	Crushing			-	Contamination Countersink	_	Instructions I Misaligned/			Part Moved	-	Wrong Stock Pulled
	Heat Trea	ıt.		-	Cut Too Short	-	Mislabeled	on center	-	Positioned V Power Loss/		Other
	Inspectio		Tube	-	Drawing	-	Misread		L		ourge	Other
	Marks/Ch	100	TUDE		Drill Holes		Off-set					
	Turning S				Finish		Out of Calibra	ation		-		
	Wave/Tw				Fit/Function		Out of Seque					

Page 2

April-22-13 12:51:53 PM

Required Date: 5/03/13

Item ID:

D4021-5

4/22/13

Accept

N900040100

Setup Start

Stop

Revision 1D:

Item Name:

Blanking Plate

20

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID Operation Description

Start Qty: 20.00

Reg'd Oty: 20.00

Set Up/ Run Hours Tool ID

Tool # Plan Code

Accept Qty Oty

Reject Reject

Insp. Number Stamp

120

120

Quality Control

Memo

QC8- Inspect parts - second check

0.00

20

130

130

Powdercoat

135

135

Quality Control

51900-11:me:9:00 Temp :3200F Finishishime:9:30 White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel

Memo

QC3- Inspect Part Finish

Memo

0.00

0.00

18xx mf 13/00

18x d Hulule

DQA:		Date:											3	DART
QA Closed:		Date:			WORK ORDER NON-	-C(ONFORM	ANCE / U		Worl	k Order uj	odate only		AEROSPACE
Work Orde	r:			- 5	DISPOSITION				AGAINST	DEPA	RTMENT	/PROCESS		
Part N				_	Rework Scrap Use-as-is Suspected Unapproved		Mad Thermofo	d-tube chining crming ge Fab	Crosstube Small Fab Finishing Composite			Water Jei d. Eng. Coor re/Packaging Supplier		Engineering Quality Other
Root				Desc	ription of work order update		Initial	Ac	tion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
						FAI	ULT CATEG	ORY						
Landin	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch Turning S	nk/Ripple at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Instructions	ncomplete/U Incomplete/ I/off center		O Pa Pa Pa	utside Dim ver/Under art Incorrec art Lost/Mi art Moved ositioned V ower Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw				Fit/Function		Out of Sequ			-				

[•]H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

100249

Page 3

Item ID:

D4021-5

Accept

N900040100

Setup Start

Stop

Revision ID:

Item Name: Blanking Plate

Required Date: 5/03/13

April-22-13 12:51:53 PM

NS2

Start Date:

4/22/13

Start Qty: 20.00 Reg'd Qty: 20.00

20

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description

Identify as per dwg & Stock Location: 570 84

Set Up/ Run Hours

Tool ID

Tool # Plan Accept Code Oty

Reject Qty

Reject

Insp. Number Stamp

140

140 Packaging

Memo

0.00

0.00

n. Ll.

13-05-31

Packaging

150

150 QC

Memo

QC21- Final Inspection - Work Order Release

Quality Control

0.00

0.00

13/6/4 A) MUS 130531

DQA:		_ Date:										TART
					WORK ORDER NON-	-C(ONFO	RMANCE / U			_	AEROSPACE
QA Closed:		Date:							W	ork Order up	odate only	
Work Orde	er:				DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
10 8 11 8 8					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing	-	re/Packaging	Other
NCR N	lo			_	Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desc	ription of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material						1						
Operator					1			2				
Offset/Setup		1										
Process												
Supplier	_										- 0	
Training	_											
Transport												
Unapproved												
						FA	ULT CAT	regory				
Landir	ng Gear				General		1		_	7		
}	Bending		W S		Bend		1	rogram	-	Outside Dim	<u> </u>	Pressure/Forced
+		lot Conce	ntric		BOM/Route		Grain		-	Over/Under		Set-up
1	Cracks	inte/ninnte	hat	-	Broken/Damage/Defect	-	Hardwa			Part Incorre	_	Temperature/Cure
}	The real Wall	ink/Ripple	/wave	-	Burrs	\vdash	1	ion Incomplete/U		Part Lost/Mi		Weld
-	Cuffs			-	Countarial	\vdash	+	ions Incomplete/	Unclear	Part Moved	_	Wrong Stock Pulled
+	Crushing Heat Tre				Countersink	_	1	ned/off center	_	Positioned V		7
-		eat on Strip in	Tuho	-	Cut Too Short	-	Mislabe		L	Power Loss/	Surge	Other
	Marks/C		Tube		Drawing Drill Holes	\vdash	Misread					
ŀ		Sequence		-	Finish	-	Off-set					
}		wist in Tub			Fit/Function		-	Calibration				

[•]H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

April-22-13 12:51:53 PM

Work Order ID:

100249

Parent Item:

D4021-5

Parent Item Name:

Blanking Plate

Start Date: 4/22/13

Required Date: 5/03/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	295.0214	0.0622	1.309474 31	101		13.05.29

Location	Loe Qty	Loc Code	
MAT020	295.0213688		
122245	0.1713688		
123136	140.8		
124428	36		
124572	118.05		

125599

DQA:		Date:												7	PART
QA Closed:		Date:			WORK ORDER NON	-C(ONFOR	IMANC	E/U		Vork Ord	er upd	ate only		AEROSPACE
Work Orde	r:				DISPOSITION					AGAINST D	EPARTM	ENT/P	ROCESS		
Part N NCR N	o				Rework Scrap Use-as-is Suspected Unapproved		N Therm	Skid-tube Machinin noforming Large Fal	g g	Crosstube Small Fab Finishing Composite	Rec,		Water Jet Eng. Coor. /Packaging Supplier		Engineering Quality Other
Root				Desc	ription of work order update		Initial		Act	tion	Sign	&		Т	-
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng		Descr	ription	Dat	e	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
						FAI	ULT CAT	EGORY							11
Landin	Bending	at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Instruction Misaligr Mislabel Misread Off-set	re on Incomp ons Incom ned/off c	nplete/l		Outside Over/Un Part Inc Part Los Part Mo Position Power I	orrect st/Miss oved ned Wre	ing ong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw	ist in Tub	e		Fit/Function		Out of Se	equence							

⁻ H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

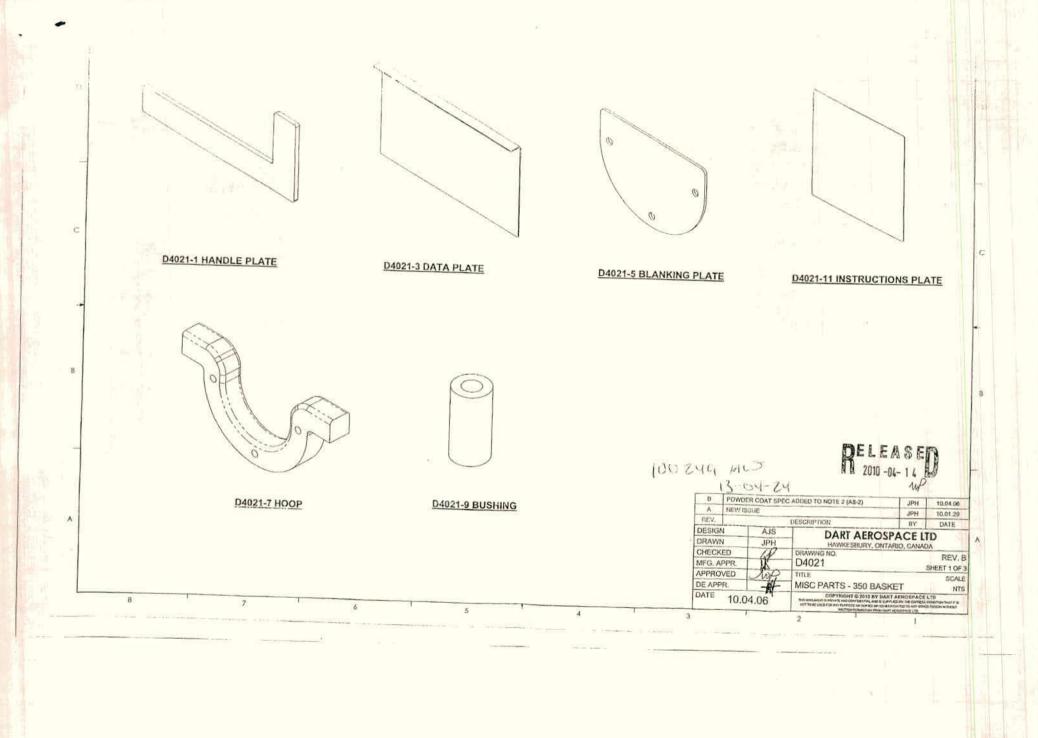
DART AEROSPACE LTD	Work Order:	100249
Description: Blanking Plate	Part Number:	D4021-5
Inspection Dwg: D4021 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	FIRST	ARTICLE II		Proto			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
Ø0.194	+0.005/-0.001	0.198	0.198		V	JKm-	C11
3.50	+/-0.030	3.491	6		v	UKm	
2.56	+/-0.030	2.559	1/		V	UKIN	CI
0.81	+/-0.030	0.81	V		_ V		_
0.060	+/-0.010	0.058	V		V		
					i,		
_							
					1 12 1		
					- 2		- 6
	, ,		240				
sured by: A		Audited by:	2		Preliminary A	pproval:	
Date: 13	05.29	Date:	13.53	0		Date:	
	hange ew Issue				Revise KJ	ed by	Approv

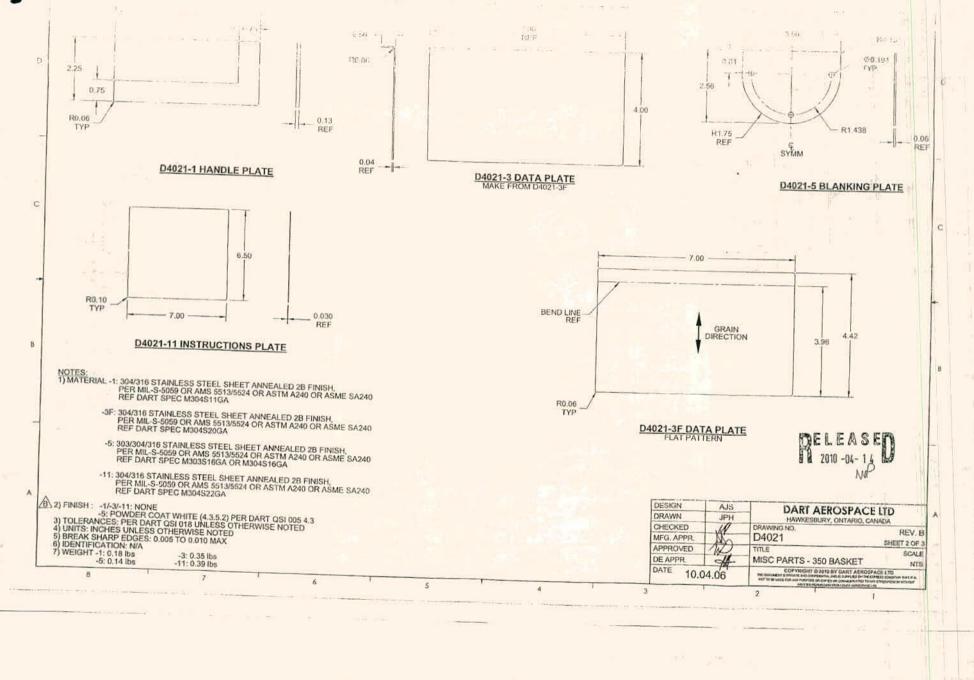
DQA:			Date:												ADT
						WORK ORDER NON-	-C(ONFOR	RMANCE /	UPDATE				L	AEROSPACE
QA Closed:			Date:								Wor	rk Order up	odate only		7.2.1.2.2.1.1.2.2.
Work Ord	er:					DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS		
	_				_	Rework			Skid-tube	Crosstube			Water Jet	Eng	ineering
Part I	Vo.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
NCD	vr=					Use-as-is			noforming	Finishing	$\overline{}$	Rec/Stor	re/Packaging		Other
NCR I	No				_	Suspected Unapproved			Large Fab	Composite			Supplier		Ш,
Root					Desc	ription of work order update		nitial	Į.	Action	T	Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	De	scription		Date	Verification	Q	C Inspector
Design															
Doc/Data						[7]									
Equip/Tooling															
Handling/Pre						N. Carlotte									
Material						i i									
Operator						31									
Offset/Setup						1									
Process)									
Supplier						1									
Training						3									
Transport		Į.													
Unapproved															
							FAI	ULT CAT	EGORY						
Landi	ng Ge	ar			12	General									
		ending				Bend		Folio/Pi	rogram			Dutside Dime	ensions	Pressu	ire/Forced
		entre No	t Concen	tric		BOM/Route		Grain				Over/Under	tolerance	Set-up	o c
		racks				Broken/Damage/Defect		Hardwar	re		F	art Incorrec	t	Tempe	erature/Cure
		rimp/Kin	k/Ripple,	/Wave		Burrs		Inspection	on Incomplete/	/Unqualified	F	art Lost/Mis	ssing	Weld	
		uffs				Contamination		Instructi	ons Incomplete	e/Unclear	F	Part Moved		Wrong	Stock Pulled
	C	rushing				Countersink		Misaligi	ned/off cente	r	F	ositioned W	/rong		
	H	leat Trea	t			Cut Too Short		Mislabel	led		F	ower Loss/S	Surge	Other	
	-li	rspection	Strip in	Tube		Drawing		Misread							
	N	1arks/Ch	atter			Drill Holes		Off-set							
	Т	urning Se	equence			Finish		Out of C	alibration						
	V	Vave/Tw	ist in Tub	е		Fit/Function		Out of Si	equence		_				

⁻ H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



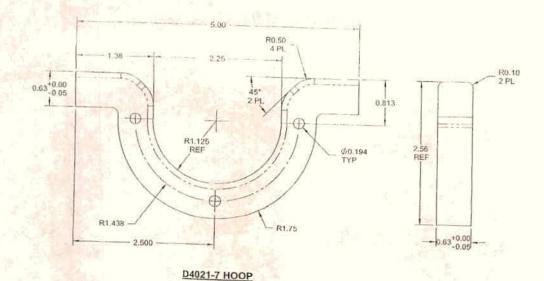
DQA:			Date:										TART
						WORK ORDER NON	-C(ONFO	RMANCE / UPI	DATE			AEROSPACE
QA Closed:			Date:							V	ork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
						Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	Vo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No				=	Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		Initial	Actio	n	Sign &		
Cause	D	ate	Step	Qty		or non-conformance	Ch	nief Eng	Descrip	tion	Date	Verification	QC Inspector
Design			1									l l	
Doc/Data													
Equip/Tooling	_												
Handling/Pre	_												
Material		- 1											
Operator		- 1											
Offset/Setup	_	1					1						
Process	_												
Supplier	-												
Training		1											
Transport													
Unapproved							EAL	ULT CAT	ECOPY				
Landir	ng Gear	8				General	FA	OLI CAI	EGORT				
[nding				Bend]Folio/P	rogram		Outside Dim	onsions [Pressure/Forced
ŀ	-	The state of the s	t Concen	tric		BOM/Route	\vdash	Grain	rogram	-	Over/Under	_	Set-up
	Cra					Broken/Damage/Defect	\vdash	Hardwa	re		Part Incorred		Temperature/Cure
1	_		k/Ripple/	/Wave		Burrs	-	100 miles (100 cm)	on Incomplete/Unqu	ualified	Part Lost/Mi	_	Weld
	Cuf					Contamination		1 00	ions Incomplete/Unc	_	Part Moved	_	Wrong Stock Pulled
		shing				Countersink		1	ned/off center		Positioned V		
j		at Treat	i			Cut Too Short		Mislabe			Power Loss/		Other
	Insp	pection	Strip in	Tube		Drawing		Misread					(1 tests // 8650)
	Mai	rks/Cha	itter			Drill Holes		Off-set					
	Turi	ning Se	quence			Finish		Out of C	Calibration				
	Wa	ve/Twi	st in Tub	P		Fit/Function		Out of S	equence				

⁻ H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



DQA:		Date:										DART
					WORK ORDER NON-	-C(ONFOR	MANCE / U			manuscus compto F	AEROSPACE
QA Closed:		Date				_			W	ork Order up	odate only	
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
				_	Rework		5	Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	Vo.				Scrap			lachining	Small Fab	Pro	d. Eng. Coor.	Quality
				10	Use-as-is			oforming	Finishing	-	re/Packaging	Other
NCR	No			_	Suspected Unapproved		Ĺ	arge Fab	Composite		Supplier	
Root	-			Desc	ription of work order update		Initial	Act	tion	Sign &		
Cause	Da	te Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Design												No.
Doc/Data												16-
Equip/Tooling					1							
Handling/Pre												
Material		4										
Operator												
Offset/Setup												2
Process												
Supplier												
Training												
Transport												
Unapproved						L						4
V 192						FA	ULT CATE	GORY				
Landi	ng Gear				General	_	1			7-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2		_
	Bendi		600 TW0	-	Bend	_	Folio/Pro	ogram	-	Outside Dim	-	Pressure/Forced
		e Not Conce	ntric	-	BOM/Route		Grain		_	Over/Under	The state of the s	Set-up
	Crack			-	Broken/Damage/Defect	L	Hardware			Part Incorre	-	Temperature/Cure
		/Kink/Ripple	e/Wave	-	Burrs	<u> </u>	1 8	n Incomplete/Ur		Part Lost/Mi	. 70	Weld
	Cuffs	600			Contamination	_	-	ons Incomplete/L	Inclear	Part Moved	_	Wrong Stock Pulled
	Crush	0.000		-	Countersink	_	1	ed/off center	<u> </u>	Positioned V		7.50
	Heat		Tul	-	Cut Too Short	_	Mislabele	ed		Power Loss/	Surge	Other
	100	ction Strip in	Tube	-	Drawing	_	Misread					
		/Chatter			Drill Holes	_	Off-set	w or				
		ng Sequence			Finish	_	Out of Ca					
	Wave	/Twist in Tu	be		Fit/Function		Out of Se	quence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



Ø0.38

D4021-9 BUSHING

NAP

DESIGN	AJS	DART AEROSPACE	LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CA	Production of the last of the
CHECKED	w	DRAWING NO.	REV. B
MFG. APPR.	W	D4021	SHEET 3 OF 3
APPROVED	And.	TITLE	SCALE
DE APPR.	-11	MISC PARTS - 350 BASKET	NTS
DATE 10.0	4.06	COPYRIGHT O 2010 BY DART ASROST MERCHANICE PRATE AD COPYRIGH AND SAFEKED THE MY TORK WIRD ON HAT PAPER OF COMMENCED THE	AFFECT COMPANY THAT IT IS. OF ER-SE PSYCHI HITHOUT

NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs